

Ship Jan 19

Work Order ID 127213

127213

Page 1

Monday, December 15, 2014 11:42:31 AM

Item ID: DSI 9603-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Modification

Start Date: 12/22/14 Start Qty: 1.00

1

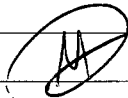
Cust Item ID:

Required Date: 1/09/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:  Date: 12-15

Tooling:

Date:

Run Start *NR1*

QC: 

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9603	A								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI9603-011 CHG001

N/A MJS 15-01-16

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

1x DAS 43 9-89 JAN 13 2015

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

1 DAS 38 9-89 15-01-15

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>*Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	*Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127213

Monday, December 15, 2014 11:42:31 AM

127213

Page 2

Item ID: DSI 9603-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Modification

Start Date: 12/22/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/09/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI9603-011

Location: _____

128665

L 15-01-16

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

MLJ 15-01-16

15-1-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Monday, December 15, 2014 11:42:37 AM

Page 1

Work Order ID: 127213

127213

Parent Item: DSI 9603-011

DSI 9603-011

Parent Item Name: Basket Modification

Start Date: 12/22/14

Required Date: 1/09/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-27 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4017-9 *D4017-9* Rib		Manufactured	No			110	Each	6.0000	4	4	DAS 43 9-89	JAN 07 2015	
										**			
										<u>B125427</u> → <u>4x</u>			
					<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>					
					WA004		6						
					125427		6						
D4623-1 *D4623-1* Bushing		Manufactured	No			110	Each	0.0000	7	7	DAS 43 9-89	JAN 07 2015	
										**			
										<u>B127216</u> → <u>7x</u>			
D4623-3 *D4623-3* Bushing		Manufactured	No			110	Each	0.0000	6	6	DAS 43 9-89	JAN 07 2015	
										**			
										<u>B127217</u> → <u>6x</u>			
D4624-1 *D4624-1* Mounting Plate		Manufactured	No			110	Each	0.0000	1	1	DAS 43 9-89	JAN 12 2015	
										**			
										<u>B127218</u> → <u>1x</u>			
AN4-12A *AN4-12A* Bolt		Purchased	No			110	Each	117.0000	7	7	DAS 43 9-89	JAN 13 2015	
										**			
										<u>M129384</u> → <u>7x</u>			
					<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>					
					FG		10						
					120423		10						
					ST344		107						
					M129384		107						

M 304EX 0.75 - 16F (WESH)

M131107 → 20xct

DAS 43 9-89
JAN 08 2015

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Monday, December 15, 2014 11:42:37 AM

Page 2

Work Order ID: 127213

127213

Parent Item: DSI 9603-011

DSI 9603-011

Parent Item Name: Basket Modification

Start Date: 12/22/14

Required Date: 1/09/15

Start Qty: 1.00

Required Qty: 1.00

AN4-14A Purchased No

110 Each 5.0000 6 6

DAS
43
9-89

AN4-14A

Bolt

** 4130716 → 16x

JAN 13 2015

Location

Loc Qty

Loc Code

FG

5

122141

5

NAS1149D0463J Purchased No

110 Each 6,583.000 26 26

DAS
43
9-89

NAS1149D0463J

WASHER

** B130799 → 26x

JAN 13 2015

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

5778

M129390

1179

M130799

4599

MS21042-4 MS21042L4 Purchased No

110 Each 0.0000 13 13

DAS
43
9-89

MS21042-4

Nut / use MS21042L4

** 130922 → 13x

JAN 13 2015

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 REV. A

REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: 10016996

1.0 PURPOSE

This Dart service instruction provides parts and instructions for modifying the basket base assembly of a D350-607-545 Heli-Utility-Basket for installation of scanning equipment.

The DSI 9603-011 kit consists of parts required to modify the basket base assembly of D350-607-545 Heli-Utility-Basket.

The DSI 9603-013 kit is an optional liner kit for customers who wish to add some protection for the equipment that will be installed inside the basket. Note that this kit is not waterproof.

2.0 MODIFICATION PROCEDURE (DSI 9603-011):

- 2.1 Disassemble basket and retain hardware.
- 2.2 Locate the D4017-9 Ribs as shown in Figure 1. It is acceptable to trim the D4017-9 Ribs to fit as required.
- 2.3 Transfer mark the location of D4017-9 Ribs onto expanded metal. Ensure there is enough surface contact of the expanded metal strands with the new D4017-9 Ribs.
- 2.4 Trim expanded metal. Remove finish locally on expanded metal and basket base structure where the new D4017-9 Ribs and D4623-1/-3 Bushings will be added.
- 2.5 Weld the new D4017-9 Ribs to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 2.6 Cut center rib. Ensure removal of the center ribs will not damage the attaching ribs of the basket structure.
- 2.7 Locate and weld in place the D4623-1/-3 Bushings as shown in Section A-A.
- 2.8 Tig weld (tack weld) the expanded metal strands to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 2.9 Ensure there is no weld flashings in D4623-1/-3 by cleaning the ID of the bushings with a size 'F' drill ($\varnothing 0.257$) as required.
- 2.10 Mask ID of D4623-1/-3 Bushings and touch up powder coat of affected areas on the base with white powder coat (4.3.5.2) per Dart QSI 005 4.3 or in accordance with ICA-D350-607.
- 2.11 Modify D4624-1 Supporting Plate per Sheet 3 of this service instruction. Mount D4624-1 plate at the bottom of basket base assembly as shown on Sheet 4 of this service instruction.
- 2.12 Re-assemble basket per ICA-D350-607. Replace any worn hardware as necessary.

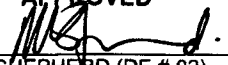
3.0 CUTOUTS FOR CAMERAS/LASERS

The following restrictions apply when using/loading the D350-607-545 Heli-Utility-Basket Modified per this service instruction:

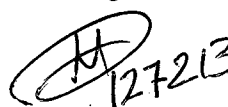
- 3.1 Cutouts for lasers/cameras that do not exceed half the hatched area of Figure 2 are allowed in the hatched areas. These cutouts must be sealed for flight with a laser/camera.
- 3.2 Lasers/cameras can be mounted to the D4624-1 Plate using appropriate hardware.
- 3.3 After drilling holes/cutouts, touch up finish with alodine and paint D4624-1 using MIL-P-85582 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint.
- 3.4 These instructions do not approve any electrical/electronic modifications required in the aircraft to operate the equipment in the basket.
- 3.5 If a basket modified per DSI 9603 is going to be used to carry loose cargo the cutouts in the D4624-1 Supporting Plate must be covered with blanking plates.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.03.30
CERT. NO.: SH94-14
ISSUE NO.: 5


127213

A	NEW ISSUE	MB	12.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9603	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION	NTS
DATE	12.03.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

4.0 INSTALLATION OF LINERS (DSI 9603-013):

- 4.1 Locate the D4628-9 Cover Plate as shown in Figure 3. It is acceptable to trim the D4628-9 to fit as required.
- 4.2 Remove finish locally on basket base structure where the D4628-9 Cover Plate will be added.
- 4.3 Weld the new D4826-9 to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 4.4 Touch up powder coat of affected areas on the base with white powder coat (4.3.5.2) per Dart QSI 005 4.3 or in accordance with ICA-D350-607.
- 4.5 Locate liners as indicated in Figure 3 (basket base) and Figure 4 (basket lid) of this service instruction.
Note: it is acceptable to trim the D4628-1/-3/-5/-7 liners to fit as required.
- 4.6 Locate and drill $\varnothing 0.257$ - $\varnothing 0.281$ " hole through D4628-1/-3/-5/-7 in center of the void of the mesh approx as shown. Deburr.
- 4.7 Secure D4628-1/-3/-5/-7 to basket mesh base/lid using provided AN4 hardware.
- 4.8 As required, it is acceptable to use more AN4 hardware (not supplied).

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9603-011	BASKET MODIFICATION
	X	DSI 9603-013	LINER
4		D4017-9	RIB
7		D4623-1 <i>Stock</i>	BUSHING, SHORT
6		D4623-3 <i>Stock</i>	BUSHING, LONG
1		D4624-1	MOUNTING PLATE <i>w/o 127218</i>
	2	D4628-1	LINER, FACE
	1	D4628-3	LINER, INBOARD
	1	D4628-5	LINER, OUTBOARD
	9	D4628-7	LINER, LID
	2	D4628-9	COVER PLATE
	98	AN4-4A	BOLT
7		AN4-12A	BOLT
6		AN4-14A	SCREW
	196	AN970-4	WASHER
13	98	MS21042-4	NUT
26		NAS1149D04639	WASHER (OR NAS1149D0432J)

6.0 WEIGHT CHANGE:

This modification adds up to 35 lbs (20 lbs from DSI 9603-011 kit + 15 lbs from DSI 9603-013 kit) to the weight of the basket which reduces the cargo carrying capacity of the basket by up to 35 lbs depending on the amount of material removed from the D4624-1 Supporting Plate. See Figure 2 of sheet 4. It is the responsibility of the installer to ensure the limitations of FMS-D350-607 and FMS-D355-607 are not exceeded.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.03.30
CERT. NO.: SH94-14
ISSUE NO.: 5

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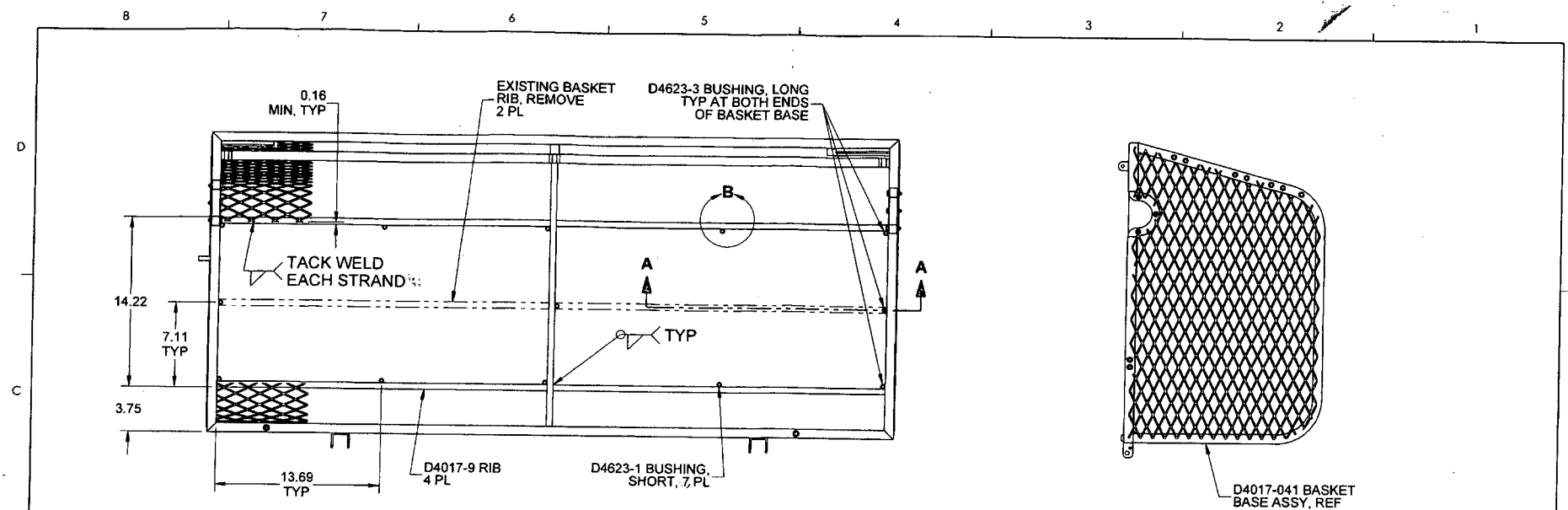
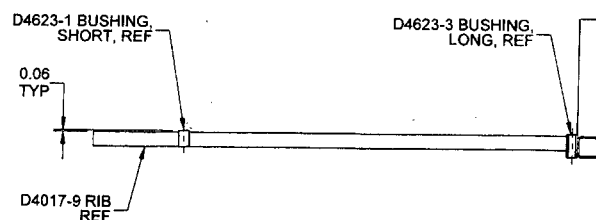
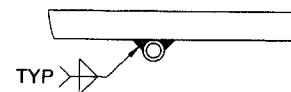


FIGURE 1: MODIFYING THE D4017-041 BASKET BASE ASSY
(MESH SHOWN PARTIALLY FOR CLARITY)



SECTION A-A: BUSHING DETAIL
SCALE 2X



DETAIL B: WELDING DETAIL
SCALE 4X

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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DSI 9603-011

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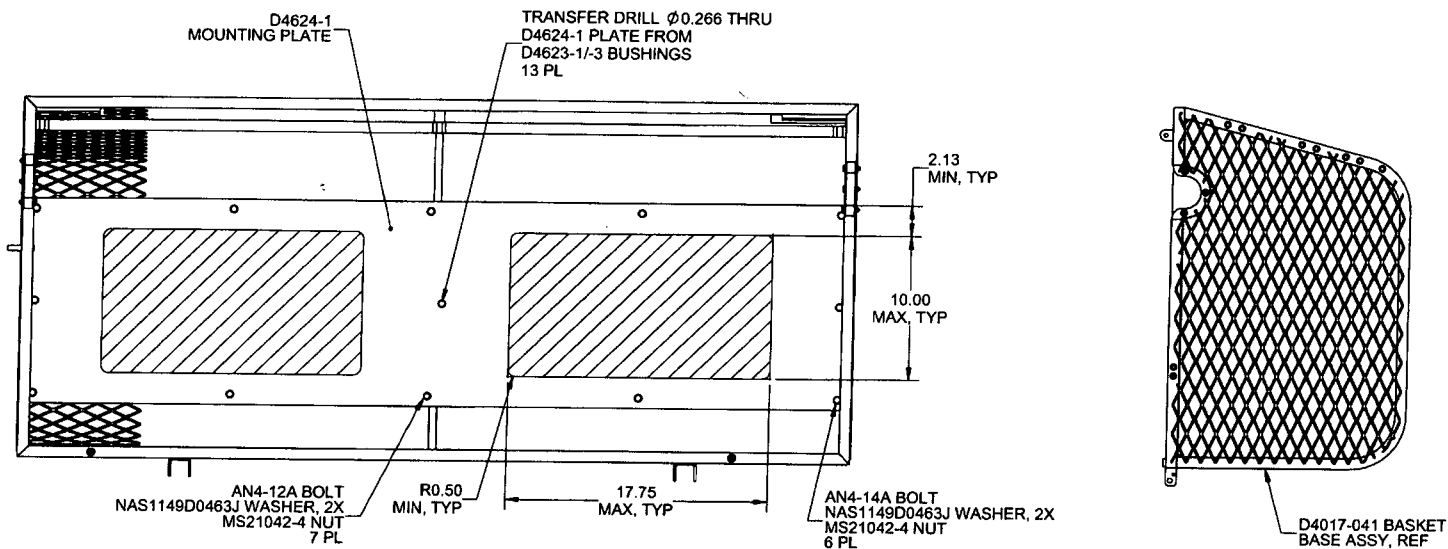


FIGURE 2: D4624-1 PLATE INSTALLATION/MODIFICATION
(MESH SHOWN PARTIALLY FOR CLARITY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
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